

ABSTRACT

An auxiliary joining element is joint to a sheet metal work-piece with a foot deformed to interlock the auxiliary joining element to the sheet metal work-piece. The foot is depressed into the sheet metal work-piece, which is retained over a die having a recess defined by a wall. The wall is interrupted by die parts that are movable radially inwardly of the wall. The foot deforms the sheet metal work-piece into the recess and simultaneously forces the die parts radially inwardly of the wall. Spaced undercuts are formed by the die parts in the foot and the deformed sheet metal work-piece for retaining the auxiliary joining element to the sheet metal work-piece.